



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D119-646-241
Job Sheet 199069



LH

Part No: D119-646-241

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Due Date: 12/2/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG IIN-D119-646 REV D, D3887-045 REV E SHEETS 4, 6-11 IPP RevA: New issue DD verified by:EC IPP REV:B 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD ver:JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD ver:JLM IPP REV:D 17.05.19 as per dwg D3887 rev.e DD ver:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	12/2/19		0.00	0.05	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		<i>TF</i>
							Skidtubes - 6		
							Skidtubes - 7		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	12/2/19		0.00	0.79	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		<i>☆ AUG 29 2019</i>
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		
							Handfinish - 1 - 16 - B4B		



Container No: S209989



Part: D119-646-241

Job No: 199069

Serial No/Batch: S209989

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17-TC STC LoA P-

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Pls 8/12/19 10:24 AM Dart.Renwick.Jennifer

Plex 8/12/19 10:24 AM Dart.Renwick.Jennife

					QC 5 - 61	
					QC 5 - 81	
130 Skidtubes - 2 - B4B	1 pcs	12/2/19	0.00 2.38	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B	TF	
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
135 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		BE
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
QC 5 - 61						
QC 5 - 81						
140 Skidtubes - 3 - B4B	1 pcs	12/2/19	0.00 2.38	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B	mbh	
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
150 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		BE
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
QC 5 - 61						
QC 5 - 81						
160 Skidtubes - 4 - B4B	1 pcs	12/2/19	0.00 2.44	Skidtubes - 1 - B4B		ND
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Plex 8/12/19 10:24 AM Dart, Renwick, Jennife		

				Skid tubes - 5 - B4B	BE
				Skid tubes - 6 - B4B	
				Skid tubes - 7 - B4B	
170 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	SEP 13 2019
				QC 5 - 9	DAS 68 9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 QC 10	1 pcs	12/2/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	BE
				QC 10 - 58	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	12/2/19	0.00 0.33	QC 10 - 9	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	SEP 17 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Powdercoat - 1 White GI(A)- B4B	1 pcs	12/2/19	0.00 0.20	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BE 19-10-3.
				Powdercoat - 4 - B4B	
START: 12.55 O.T: 3.00 FINKIT 1.25.					
210 QC 3	1 pcs	12/2/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	JUL 19-10-3
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	

Plex 8/12/19 10:24 AM Dart.Renwick.Jennifer

Plex 8/12/19 10:24 AM Dart.Renwick.Jennife

DAS 15 9-89

240 Handfinish - 4-1-Assembly-B4B	1 pcs	12/2/19	0.00 0.79	QC 3 - 61	
				QC 3 - 81	
				Handfinish - 4 - 1 - B4B	11-12-14
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
250 QC 5	1 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 19 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
260 Packaging 3-1 - Stock - B4B	1 pcs	12/2/19	0.00 0.00	QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS JAN 06 2020 58
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
265 DC - 1 - B4B	1	12/2/19	0.00 0.00	DC - 1 - B4B	21 JAN 07 2020
	pcs			DC - 2 - B4B	
270 QC 21 - FG	1	12/2/19	0.00 0.00	QC 21 - FG - 21	
	pcs			QC 21 - FG - 70	DAS
				QC 21 - FG - 53	21 JAN 07 2020

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3-Ensure squareness of
Descriptions: ends and scribe batch#

120 - (Chemical Conversion Coat per QSI005 4.1)

121 - (QC7-Inspect Chemical Conversion Coat)

125 - (QC5- Inspect part completeness to step on W/O)

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 520625 Sikaflex expire date: 07/25/2020 Start: 8:00am Time: 8:00am Finish: 5:00pm ***** (Adhere for 12 hours) *****

135 - (QC5- Inspect part completeness to step on W/O)

140 - 1- Bend FWD end of tube using bender 1 and bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurment*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow out chips from inside of tube.

150 - (QC5- Inspect part completeness to step on W/O)

160 - NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod m/39011 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4-Deburr and blow out chips from inside of tub 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

170 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.

180 - (QC10- Inspect visual per QSI004- ground welds)

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

200 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: 12:55 OVEN TEMPERATURE: 320° FINISH TIME: 1:05 - m2u886

210 - (QC3- Inspect Part Finish)

240 - 1-Install wearplates as per Dwg D3887. 2 -Inspect for foreign objects as per QSI 024 3 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 520625 Sikaflex expire date: 20-7-27 4 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 520625 Sikaflex expire date: 20-7-27 5- INSPECT TORQUE ON BOLTS AS PER DWG.

BY: _____ DATE: _____ 6-Wing Walk as per dwg QSI005 4.4 Batch: 5209367

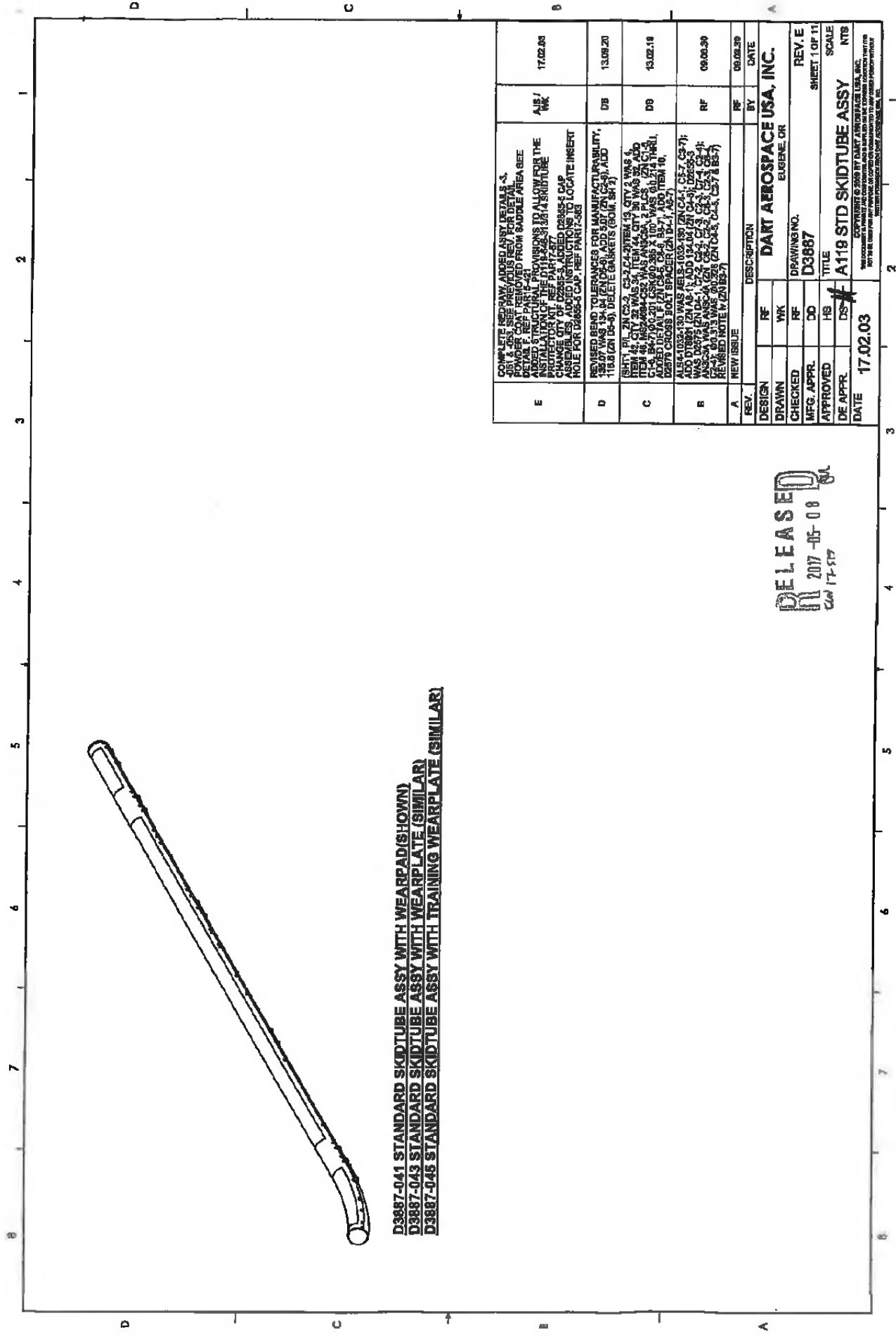
250 - (QC5- Inspect part completeness to step on W/O)

260 - (Identify as per dwg & Stock Location: _____) Location : FG108

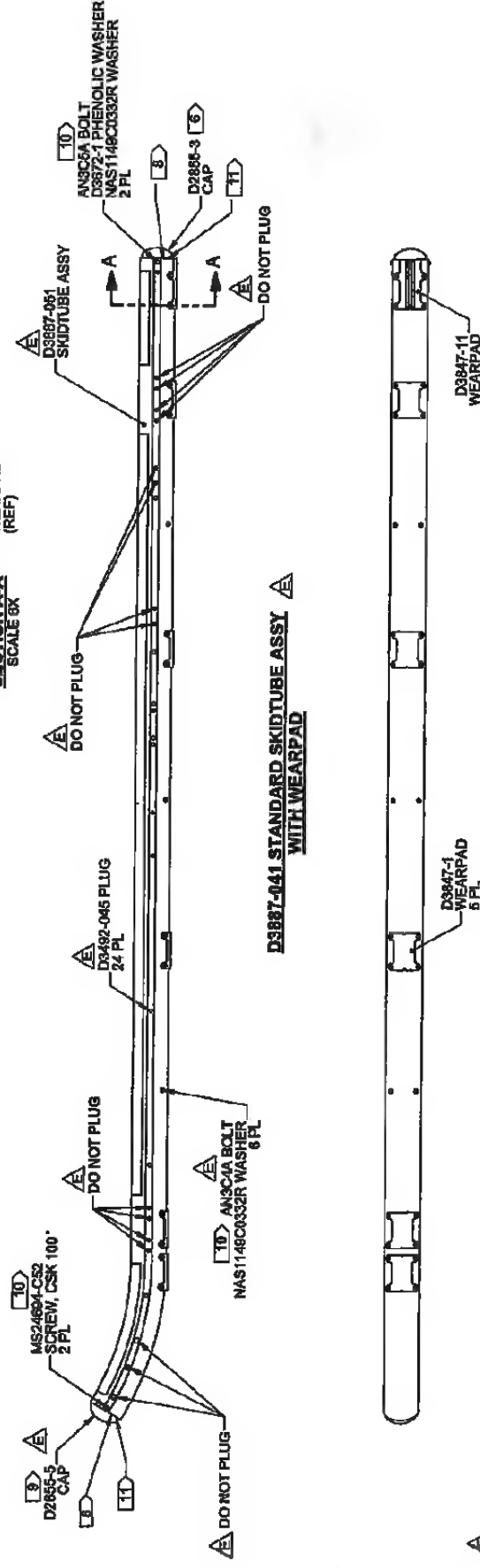
265 - Photocopy bluefile & type labels per PPP D119-846-241 CHG005

270 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - 'I' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	5168311
D3885-1	Standard Web	1 pcs (1 ea)	130-Skidtubes - 2 - B4B	5170688
D2579	Crossbolt Spacer	2 pcs (2 ea)	140-Skidtubes - 3 - B4B	5097840
D3681-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B	5211630
D3903-1	Spacer	12 pcs (12 ea)	160-Skidtubes - 4 - B4B	5211415
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-Handfinish - 4-1-Assembly-B4B	5192155
AN3C46A	Bolt	8 Ea (8 ea)	240-Handfinish - 4-1-Assembly-B4B	5203364
AN3C5A	Bolt	2 Ea (2 ea)	240-Handfinish - 4-1-Assembly-B4B	5216219
D2855-3	Cap	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	5126403
D2855-5	Cap	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	52079
D3492-045	Plug Assembly	8 pcs (8 ea)	240-Handfinish - 4-1-Assembly-B4B	5197670
D3672-1	Washer, Phenolic	2 pcs (2 ea)	240-Handfinish - 4-1-Assembly-B4B	5161008
D3849-041	Fwd Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	* 5241521
D3849-043	Aft Heavy-Duty Wearplate, Std Skid Compatible	1 pcs (1 ea)	240-Handfinish - 4-1-Assembly-B4B	5199060
D3904-1	Washer	16 pcs (16 ea)	240-Handfinish - 4-1-Assembly-B4B	5205984
MS21043-3	Nut	8 Ea (8 ea)	240-Handfinish - 4-1-Assembly-B4B	5099569
MS24694-C52	Screw	2 Ea (2 ea)	240-Handfinish - 4-1-Assembly-B4B	5067269
NAS1149C0332R	Washer (AN960C10L)	2 Ea (2 ea)	240-Handfinish - 4-1-Assembly-B4B	5193136
WAB1611-005 (x8)				5194425
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	65	0
130-Skidtubes - 2 - B4B	D3885-1	1	15	0
140-Skidtubes - 3 - B4B	D2579	2	93	0
160-Skidtubes - 4 - B4B	D3681-1	12	84	0
	D3903-1	12	79	0
240-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	1	1,206	0
	AN3C46A	8	181	0
	AN3C5A	2	936	0
	D2855-3	1	78	0
	D2855-5	1	41	0
	D3492-045	8	4	0
	D3672-1	2	1,493	0
	D3849-041	1	1	0
	D3849-043	1	7	0
	D3904-1	16	72	0
	MS21043-3	8	779	0
	MS24694-C52	2	60	0
	NAS1149C0332R	2	3,043	0
Part Specifications				
Specifications could not be found.				



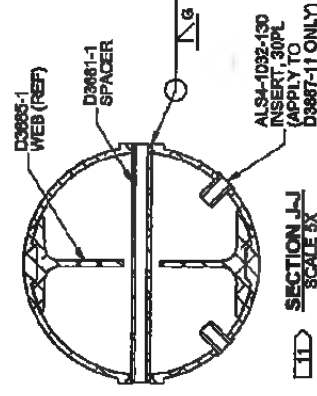
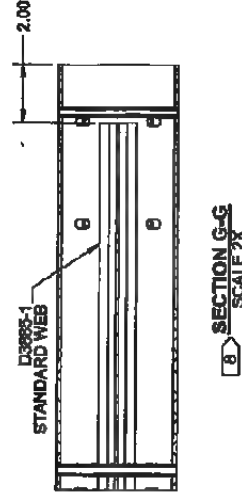
ITEM	QTY UNIT	PIN	DESCRIPTION
1	X	D3887-041	STANDARD SKIDTUBE ASSY WITH WEARPAD
2	1	D2865-3	CAP ASSY
3	1	D2865-5	CAP ASSY
4	24	D3482-045	PLUG ASSY
5	2	D3672-1	PHENOLIC WASHER
6	5	D3647-1	WEARPAD
7	1	D3647-11	WEARPAD
8	1	D3887-051	SKIDTUBE ASSY
9	1	AL54-1032-225	INSERT
10	26	AN3C5A	BOLT
11	6	AN3C4A	BOLT
12	2	MS24604-C52	SCREW, CSK 100°
13	32	NAS1148C0332R	WASHER



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI D18 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3887-041" AND BATCH NUMBER PER QSI 044 0.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE APT D2865-3 CAP
 - 7) WEIGHT: 32.0 lbs
 - 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2865-3 AND D2865-5 CAP ASSY, ALUMINE BARE MATERIAL
 - 9) USE D3887-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2865-5 CAP. OPEN HOLE TO 0.251" ALUMINE BARE MATERIAL AND INSTALL AL54-1032-225 (OR AKS7-1032-225, OR AKS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
 - 10) SEAL MATING SURFACES WITH SHARPLEX-241/281 OR PROSEAL 980 OR MIL-S-8802 CLASS B2 SEALANT
 - 11) SEAL MATING SURFACES WITH SHARPLEX-241/281 OR PROSEAL 980 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2017-05-08

DESIGN	RF	WKC	DART AEROSPACE USA, INC.
DRAWN	RF	WKC	ELUGINE OR
CHECKED	RF	WKC	D3887
INFO. APPR.	DD	WKC	SHEET 2 OF 11
APPROVED	HS	WKC	REV. E
DE APPR.	DS	WKC	TITLE
DATE	17.02.03	WKC	A119 STD SKIDTUBE ASSY
		WKC	SCALE
		WKC	NTS



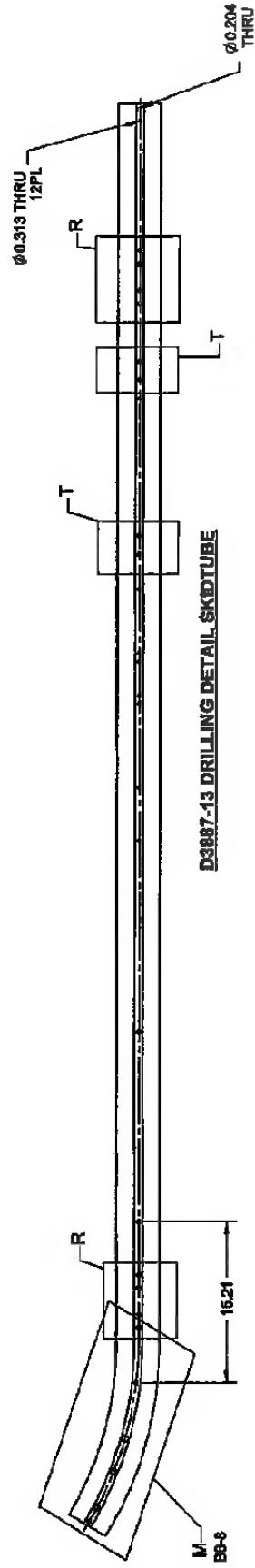
7) WEIGHT: N/A
8) INSERT D3886-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLUX-241/281 ADHESIVE PER PART C81 016 AFTER BENDING. ENSURE HOLES LINE-UP
9) MAKE THIS AREA 1/2" DO NOT POWDER CONT
10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E Ø.0275 HOLES ONLY:
1) CHAMFER HOLES Ø.0475 x .45"

11) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION J-J Ø0.313 HOLES ONLY:

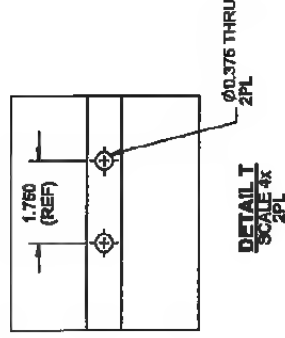
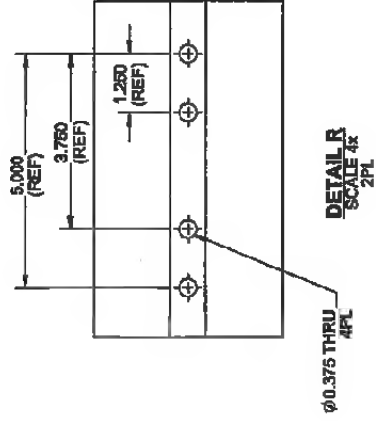
11) WELD INTO PLATE AND GRIND FLUENT
 12) DEBURR HOLES
 13) WELD PER DART 0111004

DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D3987 SHEET 7 OF 11 REV. E SCALE NTIS A119 STD SKIDTUBE ASSY TITLE COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED DATE 10-19-99 BY 60322 UCBAW NO DUPLICATION RIGHTS ARE GRANTED FOR ANY OTHER REPRODUCTION
DRAWN	WK	
CHECKED	RF	
INFG. APPR.	DD	
APPROVED	HS	
DIS. APPR.	DS	
DATE	17.02.03	

207-05-08
RELEASED
APPROVED



D3887-13 DRILLING DETAIL SKIDTUBE

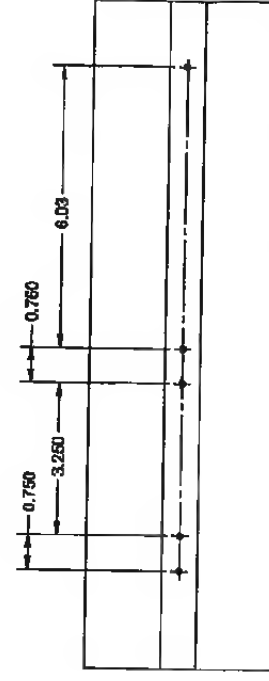
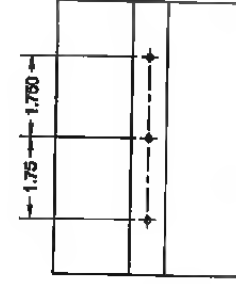
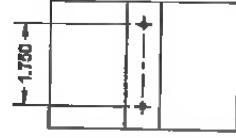
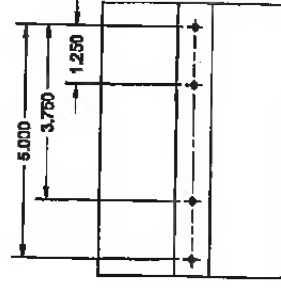
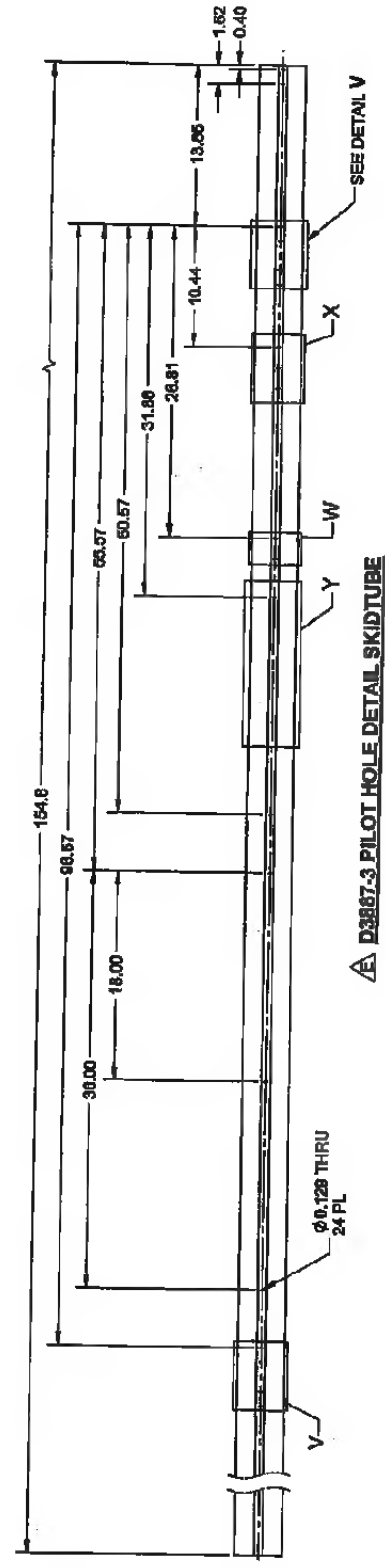


- NOTES:
- 1) MATERIAL: MAKE -13 FROM -1 BEND DETAIL
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: NA

RELEASED
2017-05-08

DESIGN	RF	RF	DART AEROSPACE USA, INC.
DRAWN	WTK	WTK	EUGENE, OR
CHECKED	RF	DRAWING NO.	D3887
INFO. APPR.	DD	REV. E	SHEET 9 OF 11
APPROVED	HS	TITLE	A119 STD SKIDTUBE ASSY
DE APPR.	DS	SCALE	NTS
DATE	17.02.03		

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NOTES:
1) MATERIAL: MAKE FROM D2000-1-180 EXTRUSION
2) FINISH: NA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.002 TO 0.010 MAX.
6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
7) WEIGHT: NA

RELEASED
2017-05-08

APPROVED

DESIGN		RF	DART AEROSPACE USA, INC.										REV. E	SHEET 11 OF 11	SCALE	MTS
DRAWN		WK	EUGENE, OR													
CHECKED		RF	DRAWING NO.													
MFG. APPR.		DD	D3987													
APPROVED		H8	TITLE													
DE APPR.		DSH	A119 STD SKIDTUBE ASSY													
DATE	17.02.03		CONTRACTOR'S ADDRESS: DART AEROSPACE USA, INC.													
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